

#### ABSTRACT OF THE DISCLOSURE

Manufacturing tools having a base and a working surface, such as trim  
steels, flange steels and die inserts, are formed by fabricating or casting a  
substrate out of a relatively ductile, low wear-resistant metal and forming the  
5 working surfaces such as cutting edges, flanging surfaces, die surfaces and die  
inserts by depositing layers of relatively hard, wear-resistant materials to the  
substrate by closed-loop direct-metal deposition or laser cladding. A multi-  
axis numerically controlled robot may be used to position and move a beam  
and deposition material over large substrates in forming such tooling.